

Date: Wednesday, 3/21/2007 3:40:58 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	STEP SPACER
Job Number	31407D		Part Number	D2279
Estimate Number	10356		Drawing Number	D2279 REV D
P.O. Number	:		Project Number	N/A
This Issue	3/21/2007	S.O. No. :	Drawing Revision	D
Prsht Rev.	NC		Material	:
First Issue	/ /	Type : SMALL /MED FAB	Due Date	4/10/2007
Previous Run	30813D		Qty:	20
Written By	:		Um:	Each
Checked & Approved By	:			
Comment	Est Rev: A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S040	2024-T3.040 sheet
-----	-------------	-------------------



Comment: Qty.: 0.1544 sf(s)/Unit Total : 3.0870 sf(s)

Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick

(M2024T3S.040)

Identify as D2279

Batch: M104025

- M1 07 06 16 (20)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D 2279

Dwg Rev: 0

Prog Rev: 0

M1 07 06 16

(20)

2-Deburr if necessary

MF 07-06-25

(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



(20)

Comment: SECOND CHECK

M1 07 06 16 (20)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



(20)

Comment: NC BRAKE

Form As per Dwg D2279

S3 08/03/19 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 20/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng			

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 3:40:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 31407D

Part Number: D2279

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



08/03/19 X2

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YL

08-03-20 X20

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/03/20

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

SB 08/03/20 20

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

108/03/20

Job Completion



U 08.03.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31407D
Description: Step Spacer	Part Number:	D2279
Inspection Dwg: D2279	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

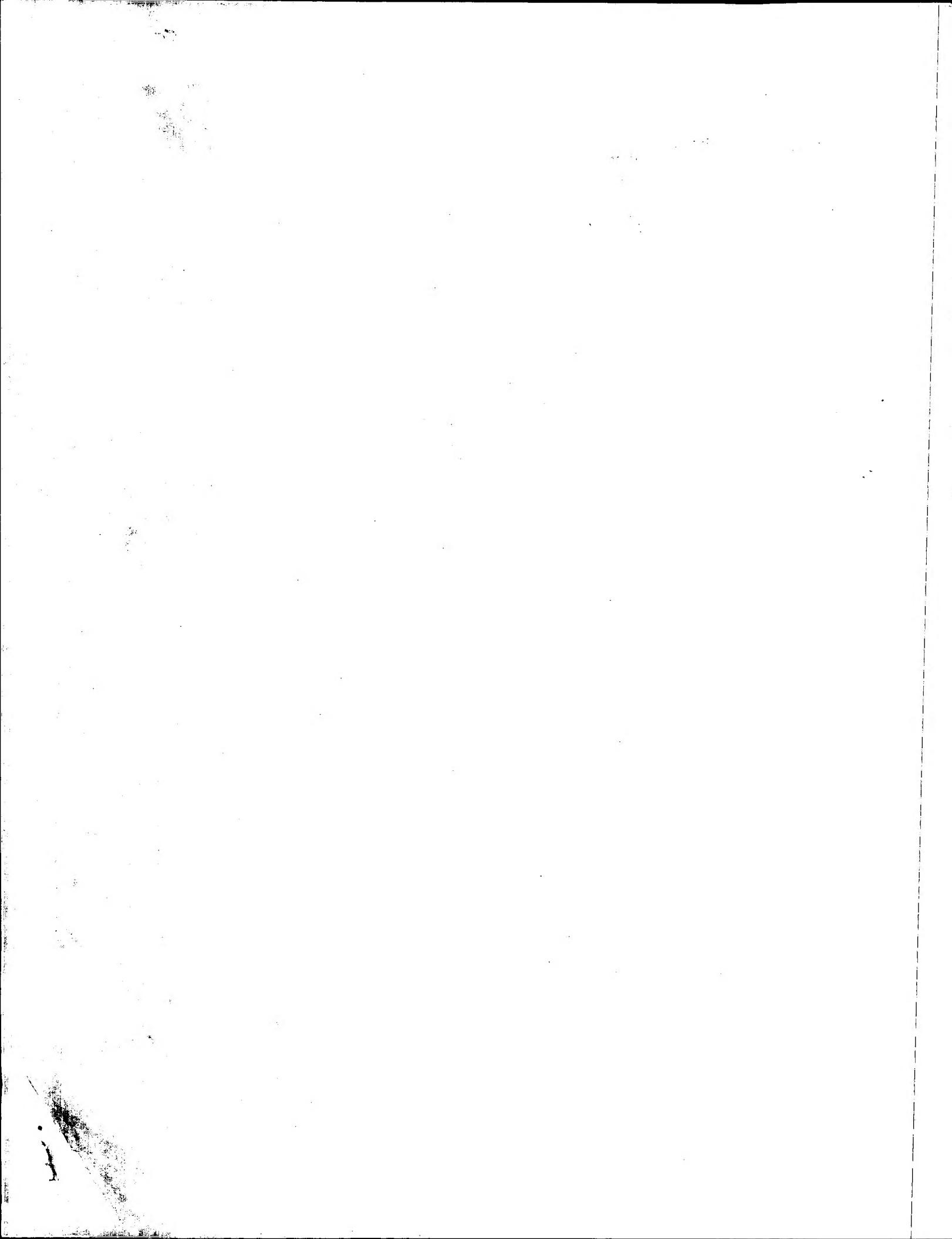
X First Article Prototype

Measured by:	MM
Date:	07/06/16

Audited by: Cm
Date: 01/06/18

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	✓



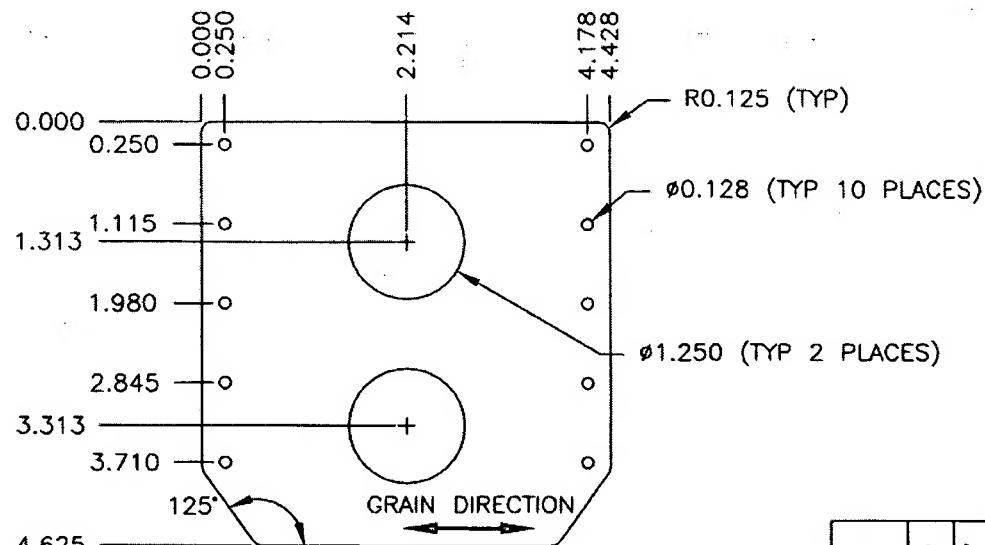


DESIGN BW		DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RE</i>	APPROVED <i>AP</i>	DRAWING NO. D2279	SHEET 1 OF 1	REV. D
DATE	TITLE		SCALE	
98.10.05	STEP SPACER		1:2	
A	94.10.13	NEW ISSUE		
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881		
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912		

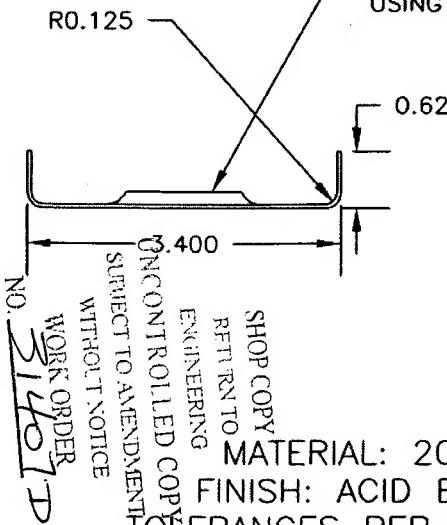
RELEASE
98.10.08 DS

~~UNDER REVIEW~~

FLAT LAYOUT



FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

